

Work Order ID 65887



Page 1

Wednesday, January 26, 2011 1:55:26 PM

Item ID: D4292-1

Accept



Setup Start



Revision ID: ~~PRELIM~~

Stop



Item Name: Fitting

Start Date: 1/26/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: H

Date: 11-01-24 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4292

PAT C

11-02-02

100

0.00



Bandsaw

BAND SAW

Memo

Cut Blank to 6.250"

Batch: ~~116867~~

116867

0.00

am 11/02/15

2 5

110

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1.

Memo

1-Machine per folio FB002

DWG REV: 9

FOLIO REV: 4A

0.00

am 11/02/15

2 5

HAAS CNC vertical machine #1

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>11/02/15</i>			<i>2</i>	<i>0</i>		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>11/02/16</i>			<i>2</i>	<i>0</i>		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>2</i>	<i>0</i>	<i>11/20/17</i>	

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Item Name: Fitting

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START: 1:45pm Temp: 320°F Fin: 1:45pm	0.00 0.00				X2	Ø	91	1/26/11
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							1/26/11 (2)
180 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							1/26/11 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Wednesday, January 26, 2011 1:55:26 PM

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Revision ID: PRELIM

Stop



Item Name: Fitting

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/17
MF
11-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 1:55:31 PM

Page 1

Work Order ID: 65887

Parent Item: D4292-1

Parent Item Name: Fitting



Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B4.000x4.00 0		Purchased	No			100	f	1.2578	0.52	2.189474			



7075-T73 Bar 4.0 x 4.0



Location

Loc Qty

Loc Code

MAT

1.2578

116153

0.2578

116324

1

M1116867 X1.041"

cm 11/02/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65887
Description: FITTING		Part Number: D4212-1
Inspection Dwg: D4202 Rev: C		Page 1 of 2

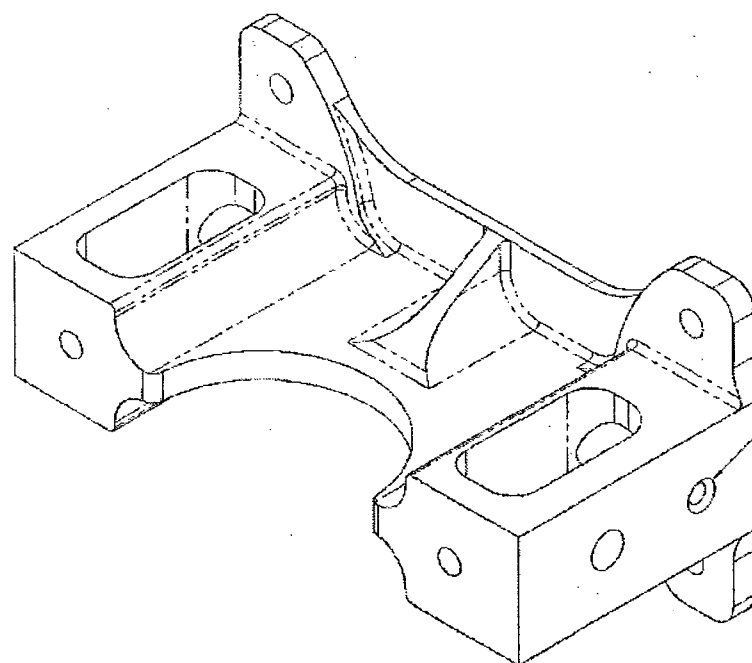
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.1250	+ .030 - .010	.1256	—		Vern	ML-7
.125	+ .030 - .010	.129	—		"	"
2.95	+ .030	2.952	—		"	"
.275	+ .010	.274	—		"	"
.800	+ .010	.801	—		"	"
.825	+ .010	.827	—		"	"
.375	+ .010	.375	—		"	"
.88	+ .030	.881	—		"	"
.663	+ .010	.658	—		"	"
Ø.381	+ .000 - .001	Ø.381	—		Micr	ML-02
Ø.320 X 100°	+ .010 X 1/2°	Ø.325 X 100°	—		Vern	ML-7
1.125	+ .010	1.125	—		"	"
1.063	+ .010	1.063	—		"	"
5.99	+ .030	5.991	—		"	"
5.86	+ .030	5.870	—		"	"
2.84	+ .030	2.843	—		"	"
.190	+ .030	.192	—		"	"
1.200	+ .010	1.201	—		"	"
3.44	+ .010	3.445	—		"	"
2.450	+ .010	2.450	—		"	"
1.325	+ .010	1.330	—		"	"
.300	+ .010	.300	—		"	"
.493	+ .010	.499	—		"	"

Measured by: <i>ML</i>	Audited by: <i>M.A</i>	Preliminary Approval:
Date: 11/02/15	Date: 11/02/16	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



MS21209F1-10 HELICAL COIL, 1X
REF

GRAIN
DIRECTION

D4292-1 FITTING

RELEASED
2011-02-01

NOTES:

- 1) MATERIAL: 7075-T73/T7351/T73510/T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4292-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.02 lbs

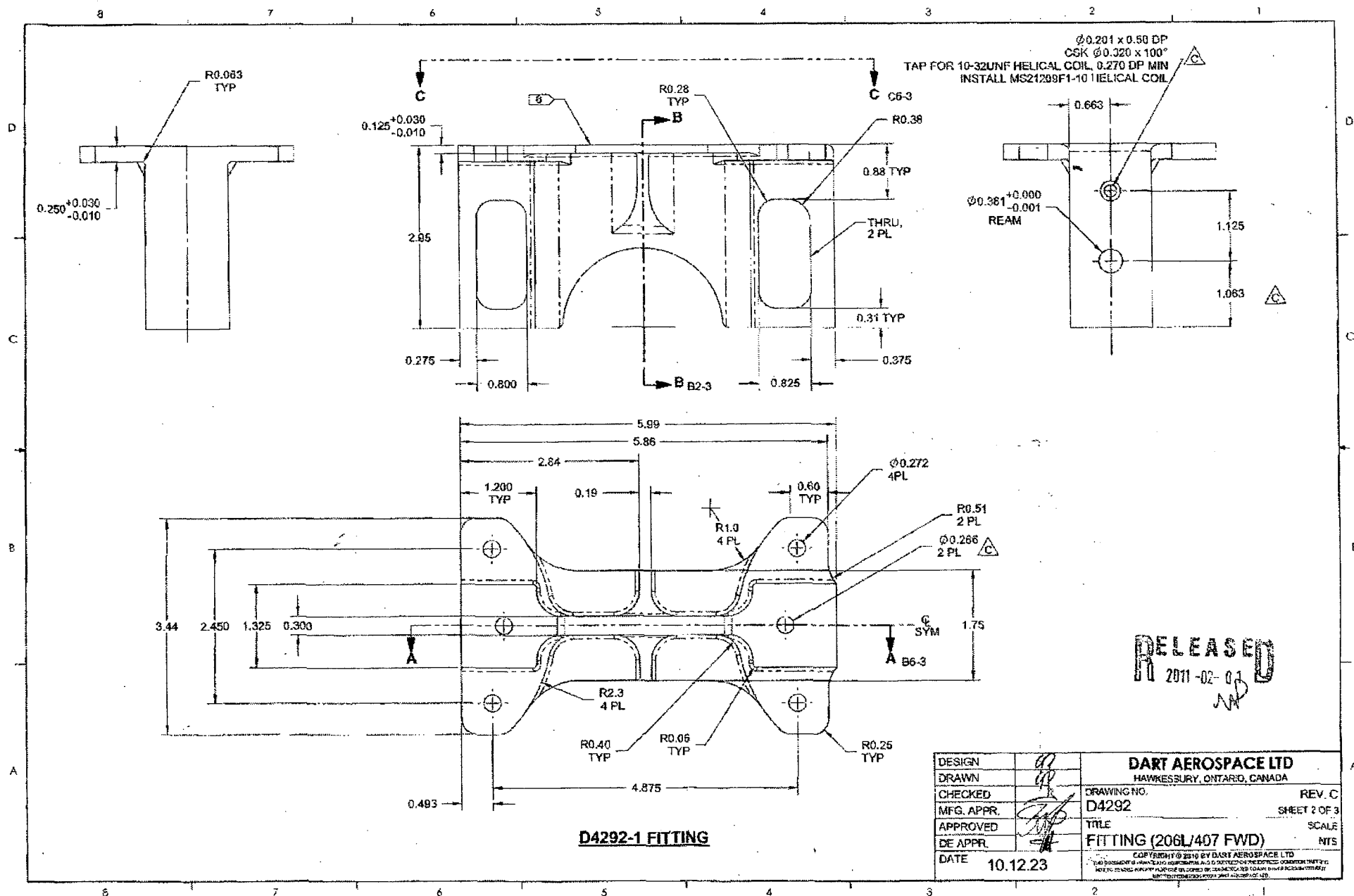
C	1.064 WAS 1.235 (C1-2), Ø0.288 WAS Ø0.323 (B3-2). ADD HELICAL COIL (D4-2)	CP	10.12.23
D	0.890 WAS 0.78 (C8-2), 0.825 WAS 0.81 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4292** REV. C
SHEET 1 OF 3

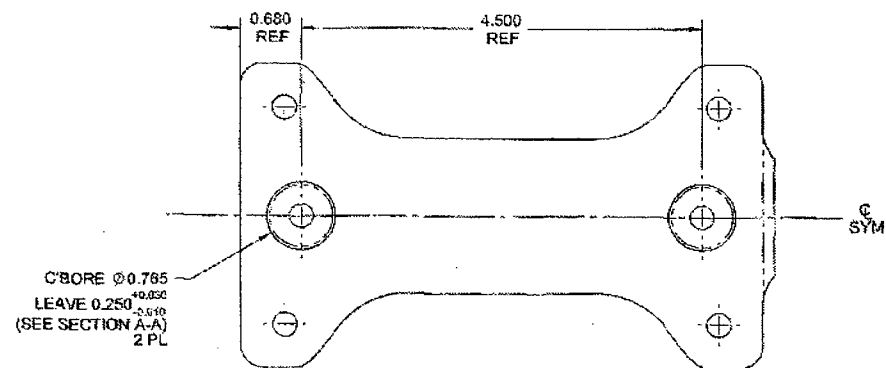
TITLE **FITTING (206L/407 FWD)** SCALE **NTS**

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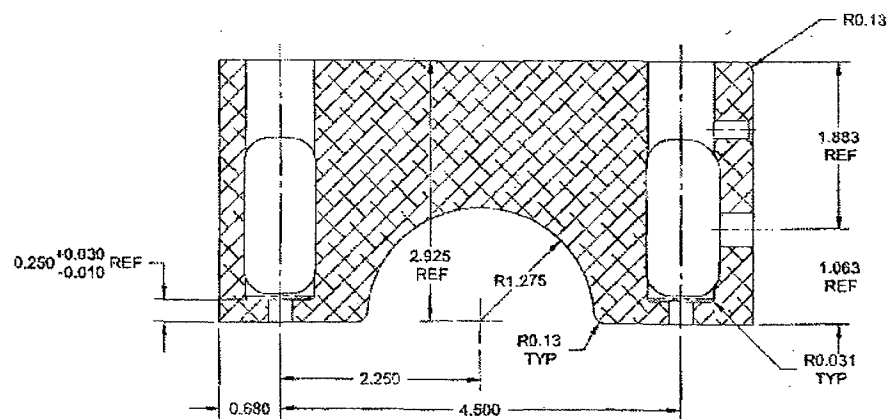


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2011-02-01

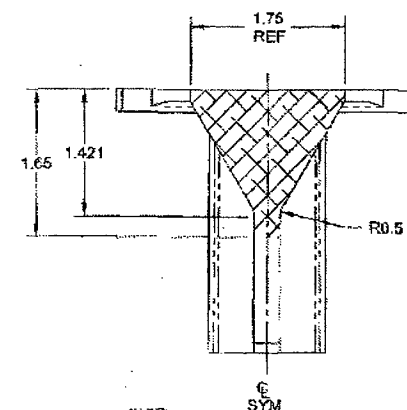
8 7 6 5 4 3 2 1



VIEW C-C D3-2



SECTION A-A A3-2



SECTION B-B C4-2

RELEASED
2011-02-01
JWW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4292	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (206L/407 FWD)	
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8 7 6 5 4 3 2 1